

Work Order ID 51869

Tuesday, September 08, 2009 12:39:15 PM



Page 1

Item ID:	D3825-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Basket End)					
Start Date:	9/9/2009	Start Qty:	6.00		Cust Item ID:	
Required Date:	9/14/2009	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09-08	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A								

100
 Large Fab 0.00
 Large Fab Memo 0.00
 Large Fab 1- cut D3825-1 rib as per dwg D3825-2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825-3- c'sink hole as per dwg 4- remove identification markings 5- deburr

110
 QC 0.00
 Quality Control Memo 0.00
 QC5- Inspect part completeness to step on W/O
 => 8/1/15

120
 Large Fab 0.00
 Large Fab Memo 0.00
 Large Fab 1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825-2 A/R ER316 S.S. Rod Batch: M109213 2- grind bushing weld flush where indicated on dwg D3825 3- deburr if necessary

→ 8/1/15 6x
 (76) /






8/1/15 (6)



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Item ID: D3825-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket End)
Start Date: 9/9/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 9/14/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	<i>QC09-09.16</i>				_____	_____	_____
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>27802/02/16</i>				<i>(X6)</i>	<i>/</i>	_____
150  Packaging Packaging	Identify as per dwg & Stock Location: _____ <i>Basket cell</i> Memo	0.00 0.00	<i>84 09/09/16</i>				<i>(6x)</i>	_____	_____

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Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 9/9/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/14/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/18

BT 09-9-17

Picklist Print

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Work Order ID: 51869

Parent Item: D3825-041RevA

Parent Item Name: Rib Assembly (Basket End)



Start Date: 9/9/2009

Required Date: 9/14/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD 		Manufactured	No			100	Each	56.0000	6.0000			
Spacer Bushing												

Warehouse

Loc Qty

Loc Code

Location

Premier

Mezz

46

44274

37

44365

9

Main Warehouse

ST

10

51126

10

D3759-1RevA

Manufactured No

100

Each

66.0000

6.0000



Bushing



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

66

51136

30

51473

36

bx *SY 09/09/15*

bx *SY 09/09/15*

Picklist Print

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Work Order ID: 51869



Parent Item: D3825-041RevA



Parent Item Name: Rib Assembly (Basket End)

Start Date: 9/9/2009

Required Date: 9/14/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	1,117.989	13.4211			

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

1117.98898

112344

117.98898

112398

1000

112344

END BAR
SCRAP

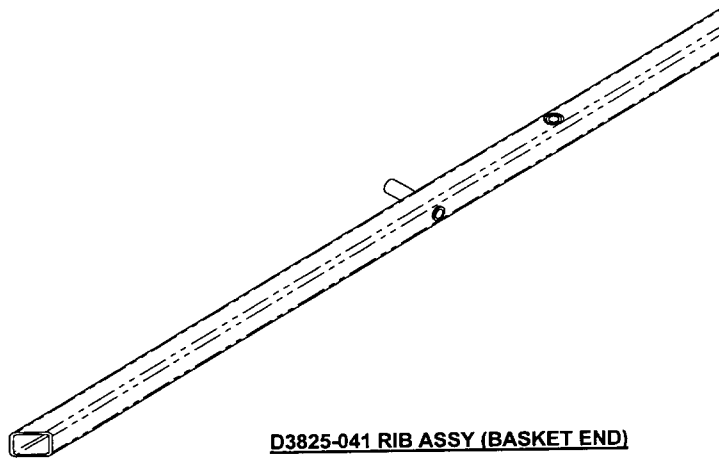
13.4211

8/09/09/15

1.5

14.9211

ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51869

RELEASED
03/11/18

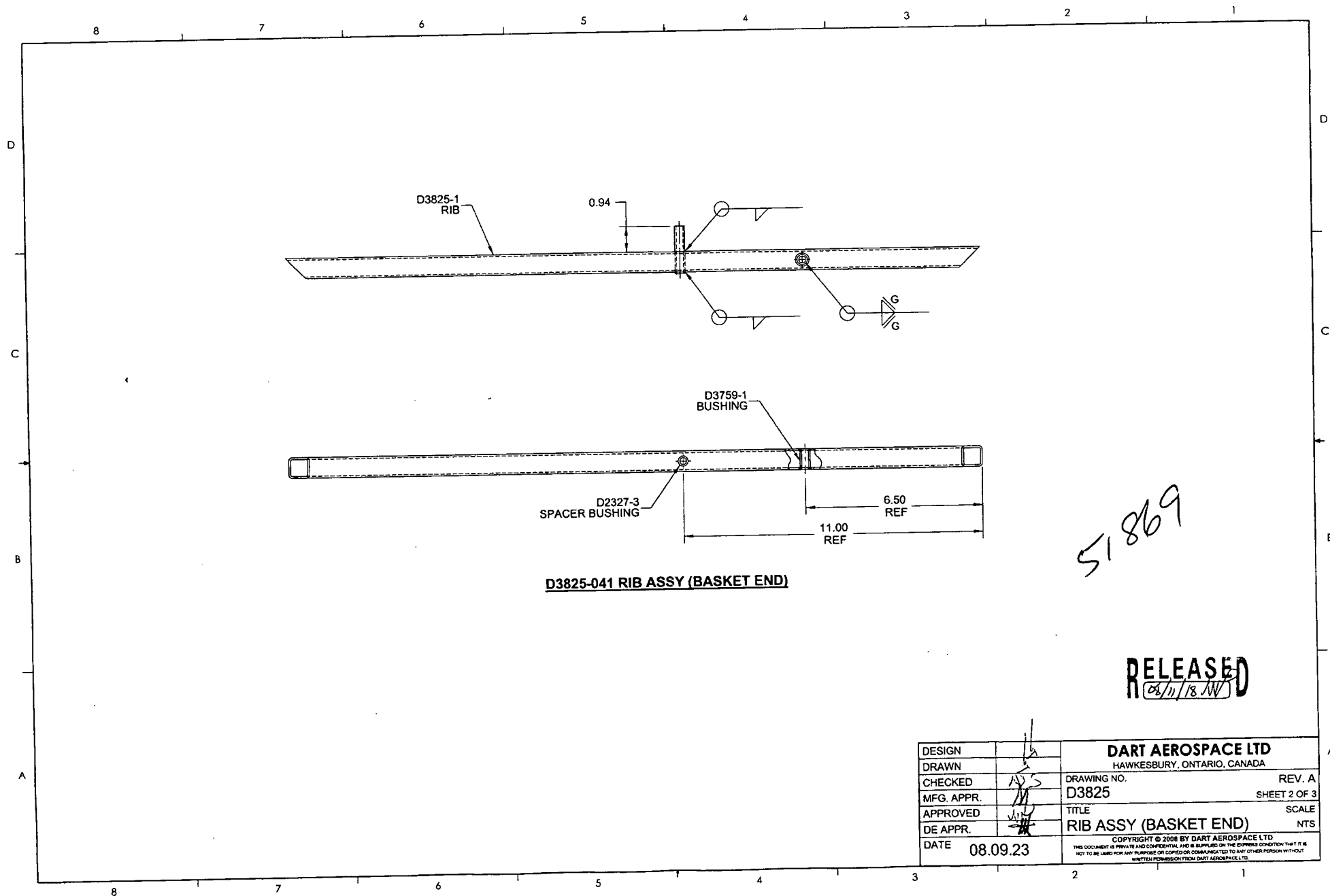
- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) WELDING: PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	MB	08.09.23
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.23			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

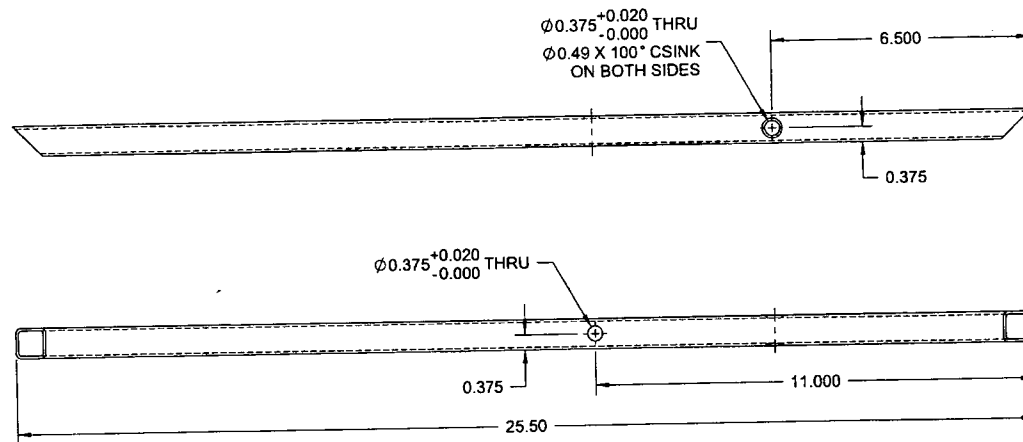
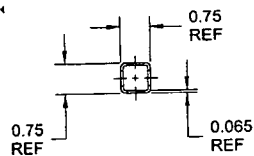
DRAWING NO. **D3825** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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08/11/18 W

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AY	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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D3825-1 RIB

51869

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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